



Dart Aerospace Ltd.
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D4931-5 Job Sheet 189915



Part No: D4931-5

Job Qty: 10 pcs

Part Name: Engine Fitting (for B3e models)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/31/19

Job Tracking No:

Due Date: 3/4/19

Created By: Dara Macdonald

Type: ~~SOLD~~ STOCK

Description:

Note: DWG REV A SHEET 3 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	10 pcs	3/4/19	3/4/19	0.00	8.70	Doosan - 1		2019-03-21 PMP
110	QC 2	10 pcs	3/4/19	3/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		2019-03-21 PMP
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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				QC 2 - 8	
112	Conventional Mill - 1 - B4B	10 pcs	3/4/19	0.00 4.13	Conventional Mill - 1 - B4B
					Conventional Mill - 2 - B4B
115	QC 2	10 pcs	3/4/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 38
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 54
					QC 2 - 56
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
120	QC 8	10 pcs	3/4/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 38
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
130	Packaging 3-2 - Stock - B4B	10 pcs	3/4/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	5/127
				Packaging 3 - 28 - B4B	APR 02 2019
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	10 pcs	3/4/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

Part Op 100 - (Doosan Lathe) Machine as per folio FB210
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 112 - (Manufacture as per dwg) DRILL HOLES AS PER REQUIRED
 115 - QC2- Inspect parts off machine FAI/FAIB)
 120 - QC8- Inspect parts - second check)
 130 - Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	1.5000 ft (15 ea)	100-Doosan - 1	5018010
				33.924

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R2.000	2	16	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



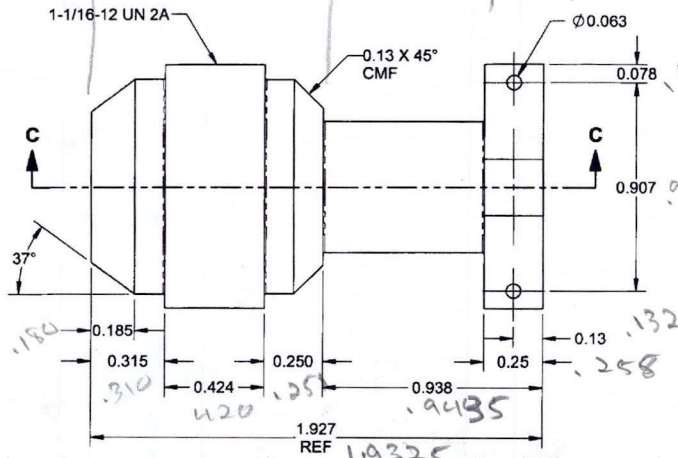
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

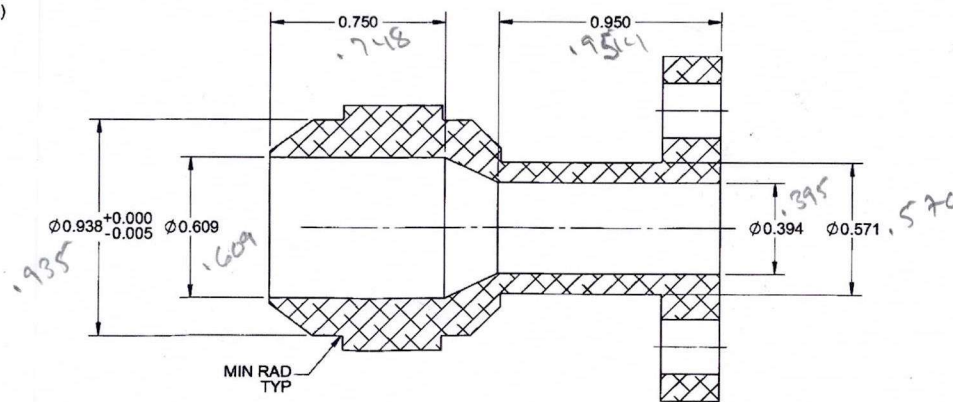
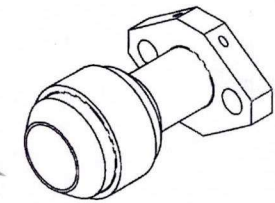
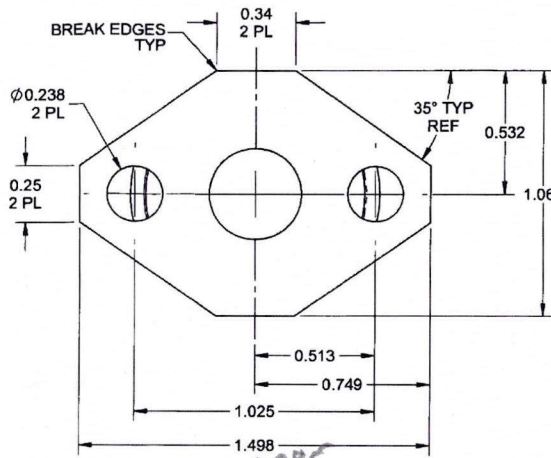
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

MADOR $\phi 1.057$



D4931-5 EAPS P2 ENGINE FITTING
(FOR B3 MODELS WITH ARRIEL 2D ENGINES)



RELEASED
2014-01-08

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

SECTION C-C

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4931	SHEET 3 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EAPS P2 ENGINE FITTING	NTS
DATE	13.09.20	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 189915
Description: EAPS P2 Engine Fitting		Part Number: D4931-5
Inspection Dwg: D4931	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	N/A		✓			
37°	+/-0.5°	37.2	✓			
0.185	+/-0.010	.182	✓			
0.315	+/-0.010	.312	✓			
0.424	+/-0.010	.425	✓			
0.250	+/-0.010	.250	✓			
0.938	+/-0.010	.943	✓			
1.927 Ref	+/-0.010	1.932	✓			
0.25	+/-0.030	.255	✓			
0.13	+/-0.030	.1305	✓			
0.907	+/-0.010	.908	✓			
0.078	+/-0.010	.079	✓			
Ø0.063	+0.004/-0.001	.062	✓			
0.13 x 45°	+/-0.030 x +/-0.5°	.133 x 45	✓			
0.34	+/-0.030	.345	✓			
0.25	+/-0.030	.255	✓			
Ø0.238	+0.005/-0.001	0.238	✓		Vernier ID5	
35°	+/-0.5°	35.3°	✓			
0.532	+/-0.010	.5305	✓			
1.063	+/-0.010	1.061	✓			
0.513	+/-0.010	0.513	✓			
0.749	+/-0.010	.7485	✓			
1.025	+/-0.010	1.025	✓		Vernier ID5	
1.498	±0.010	1.497	✓			
φ .609	±0.010	.609	✓			
.750	±0.010	.754	✓			
.950	DAS .010	.948	✓			

Measured by: PMP 56 9-89	Audited by: L.C.	Preliminary Approval:
Date: 2019-03-21	Date: 19-03-28	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	

φ .394 ±.010 .396 *Good*
 φ .571 ±.010 .5695 ✓